

Date: Tuesday, 06/05/2008 3:49:05 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 407 HIGH AFT X-TUBE ASSEMBLY
Job Number	: 39078		
Estimate Number	: 10528		
P.O. Number	:	Part Number	: D407667205
This Issue	: 06/05/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D407-667-245 REV D
First Issue	: 11	Project Number	: N/A
Previous Run	: 38168	Drawing Revision	: D
	Type : CROSSTUBES	Material	:
Written By	:	Due Date	: 13/05/2008
Checked & Approved By	: <u>JD 08.05.08</u>	Qty:	1 Um: Each

Comment: Est Rev:C 05.09.02 Add holes for compatibility with Bell Skidtubes KJ/JLM
 Est Rev:D Added Magnobond, Rubber Cushion & Clamps 07-02-19 JLM

****CHANGE TO CHG 005 - IF USING D2894-1 B35578 OR GREATER****

Additional Product

Job Number:



SCRAP

Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D407-667-205CHG004

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

3.0	D407667205TRN	CROSSTUBE TURNING DETAIL
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch 38791

PT 08.05.14

4.0	BENDING	BENDING MACHINE - SKIDTUBES
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**Comment:** LANDING GEAR RESOURCE 1




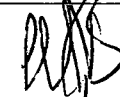

1-Bend tube as per Dwg D407-667-245 using CNC bender program 407 Aft and Folio FT

EL 8-5-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D467-467-205 PAR #: N/A Fault Category: X-tube NCR: (Yes) No DQA: AD Date: 08/05/20
 QA: N/C Closed: AD Date: 08/05/20

NCR: 39078		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/20	4.0	Tube is badly bent on one side. Bends are passed the outside tangent line, and the tube is kinked from the center roller, on the automatic program.	 08/05/20	- Scrap tube. - QC will supervise tubes being bent. - Tubes to be bent with manual programs.	 08/05/20	 08/05/20	 08/05/20	 08/05/20

NOTE: Date & initial all entries

Date: Tuesday, 06/05/2008 3:49:05 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 HIGH AFT X-TUBE ASSEMBLY

Job Number: 39078

Part Number: D407667205

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

6.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D407-667-245. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D407-667-245. Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D407-667-245. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D407-667-245

6-Drill Aft rivet holes using drill Jig DT8789 as per Dwg D407-667-245. Note: Aft side has 3x top holes.

7-Drill Fwd rivet holes using drill Jig DT8789 as per Dwg D407-667-245. Drill only the top (3) holes.

8-C'sink holes as per Dwg D407-667-245. Allow rivet to sit below surface to compensate for paint.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D407-667-245

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 06/05/2008 3:49:05 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 HIGH AFT X-TUBE ASSEMBLY

Job Number: 39078

Part Number: D407667205

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

10.0	OUTSIDE SERVICE	OUTSIDE SERVICES
------	-----------------	------------------



Comment: Sub-Contracting OUTSIDE SERVICES
Liquid Penetrant Inspection as per QSI 038Or
Issue P/O: _____ LPI as per ASTM 1417
~~Level 2 Attach copy of NDT results to work order~~

11.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
Inspect for transit damage
Ensure copy of NDT results attached to work order.

12.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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Comment: DIMENSIONAL CHECK OF X-TUBES

13.0	SPRAY PAINTING	SPRAY PAINTING
------	----------------	----------------



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

14.0	QC14	INSPECT SPRAY PAINT
------	------	---------------------



Comment: Inspect Spray Paint
Wrap in plastic bag to protect from scratches

15.0	D2856400	Abrasion Strip
------	----------	----------------



Comment: Qty.: 1.3524 f(s)/Unit Total : 1.3524 f(s)
Pick:
Qty Part number Description Batch
2 D2856-400(Cut to 7.73") Abrasion Strip _____

16.0	D2873043	Nut Plate Assembly
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part number Description Batch
2 D2873-043 Nut Plate _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 06/05/2008 3:49:05 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 HIGH AFT X-TUBE ASSEMBLY

Job Number: 39078

Part Number: D407667205

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045 Nut Plate _____

18.0

D28941

2.750 Support



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2894-1 Support _____

19.0

D31901

Chafing Shield



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D3190-1 Chafing Shield _____

20.0

D3595

Rubber Cushion (per sq ft)



Comment: Qty.: 0.0246 sf(s)/Unit Total : 0.0246 sf(s)

Rubber Cushion

2X .750" X 4.30"

Batch: _____

21.0

MS20601AD4W8

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W8 Rivet _____

22.0

MS2192022

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-22 Clamp _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 06/05/2008 3:49:05 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 HIGH AFT X-TUBE ASSEMBLY

Job Number: 39078

Part Number: D407667205

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

MS2192025

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp(per MIL-DTL-8783C)

Batch: _____

24.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8674. Install chafing shield as per Dwg D407-667-245.Note:
(3) top holes should be facing up.

2- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

3-Install support with magnobond and install clamps as per Dwg D407-667-245. Torque clamps to 80-100 in
lb

A/R Magnobond Batch: _____

EXP: _____

4-Install nut plates as per Dwg D407-667-245. Touch-up rivet heads with Imron paint.

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

27.0

AN534A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: _____

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

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Drawing Name: 407 HIGH AFT X-TUBE ASSEMBLY

Job Number: 39078

Part Number: D407667205

Job Number:



Seq. #:	Machine Or Operation:	Description :
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28.0	MS21042L5	Nut
------	-----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Nut
Batch: _____

29.0	AN510A	Bolt
------	--------	------



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)
Pick:Packing Kit
Qty Part number Description Batch
10 AN5-10A Bolt _____

30.0	AN532A	Bolt
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:Packing Kit
Qty Part number Description Batch
4 AN5-32A Bolt _____

31.0	AN960JD516	Washer
------	------------	--------



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)
Pick:Packing Kit
Qty Part number Description Batch
18 AN960JD516 Washer _____

32.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
------	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

33.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
Identify and in kanban rack
Location: _____

34.0	QC21	FINAL INSPECTION/W/O RELEASE
------	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-05-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 391078
Description: Crosstube Assembly	Part Number: D407-667-245
Inspection Dwg: D407-667-245 Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

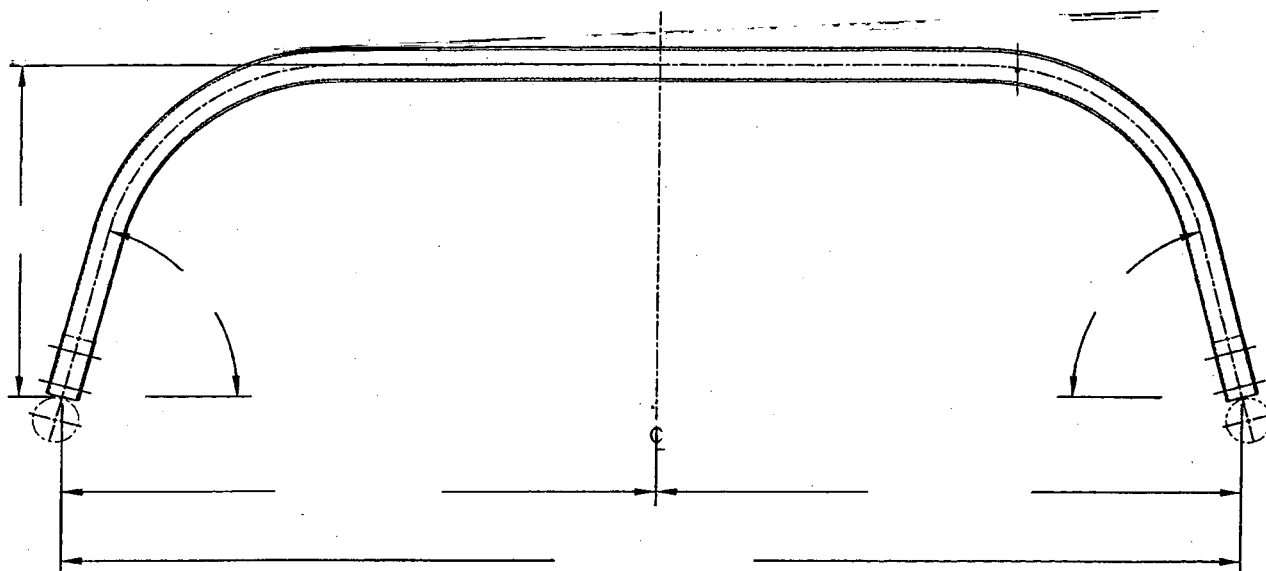
	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.490	+0.005/-0.000					
	1.832	+0.005/-0.000					
	1.838	+0.005/-0.000					
	1.892	+0.005/-0.000					
	2.052	+0.005/-0.000					
	2.206	+0.005/-0.000					
	2.521	+0.005/-0.000					
	2.633	+0.005/-0.000					
	4.10	+/-0.030					
	4.978	+/-0.030					
	2.040	+0.000/-0.010					
	0.125	+/-0.010					
	R0.063	+/-0.010					
	R0.500	+/-0.010					
SIDE B	2.490	+0.005/-0.000					
	1.832	+0.005/-0.000					
	1.838	+0.005/-0.000					
	1.892	+0.005/-0.000					
	2.052	+0.005/-0.000					
	2.206	+0.005/-0.000					
	2.521	+0.005/-0.000					
	2.633	+0.005/-0.000					
	4.10	+/-0.030					
	4.978	+/-0.030					
	2.040	+0.000/-0.010					
	0.125	+/-0.010					
	R0.063	+/-0.010					
	R0.500	+/-0.010					
	112.91	+/-0.020					

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.21	New Issue (P/O D407-667-205)	KJ/RF	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	06.03.30	Tolerance revised for 4.978 dimension	KJ/JLM	
D	07.02.19	Dwg Rev updated	KJ/JLM	

DART AEROSPACE LTD		Work Order:	39078
Description: Crosstube High Aft (407)		Part Number:	D407-667-205
Inspection Dwg: D407-667-245 Rev: D		Page 1 of 1	

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	45.86	45.98
Angle	54	56
Total Span	91.72	91.96



Comments

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	<i>[Signature]</i>

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D407-667-245	REV. D SHEET 1 OF 3
DATE 07.02.07		TITLE CROSSTUBE ASS'Y (407 HIGH AFT)	SCALE NTS
A	02.05.13	NEW ISSUE	
B	03.05.21	ADD CHAFING SHIELD	
C	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
D	07.02.07	ADD VIEW FOR OEM SKID HOLES, ROTATE ORIENTATION OF CLAMPS SECTION F-F, REMOVE -851 ABRASION STRIP, ADD MAGNOBOND 6398, ADD CUSHION	

RELEASED

07.02.14 H

Qty	Part Number	Description
X	D407-667-245	CROSSTUBE ASSEMBLY (407 HIGH AFT)
1	D6011-115	CROSSTUBE
2	D2856-400-773	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
1	D2894-1	SUPPORT
2	D3190-1	CHAFING SHIELD
2	D3595-075-430	RUBBER CUSHION
14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
4	MS21920-22	CLAMP
2	MS21920-25	CLAMP (OR MS21920-24)

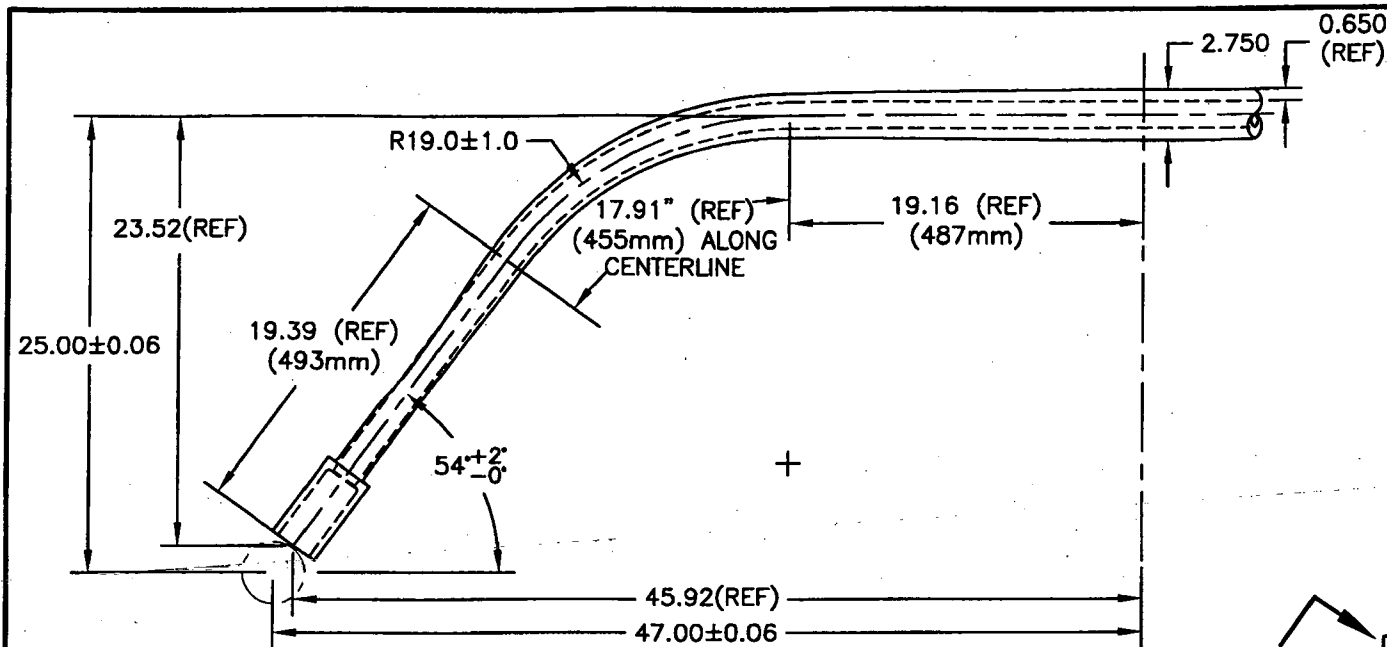
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6011-115
FINISHED LENGTH = 112.91±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) INSTALL D2894-1 CENTER SUPPORT USING A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-25 CLAMPS WITH D3595-075-430 RUBBER CUSHIONS TO SECURE D2894-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
NOTE: MS21920-24 CLAMPS CAN BE USED TO ACCOMMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB.
- 14) INSTALL D3190-1 CHAFING SHIELDS SO THAT OVERLAP IS ON BOTTOM SIDE OF CROSSTUBE OPPOSITE D2894-1 SUPPORT.

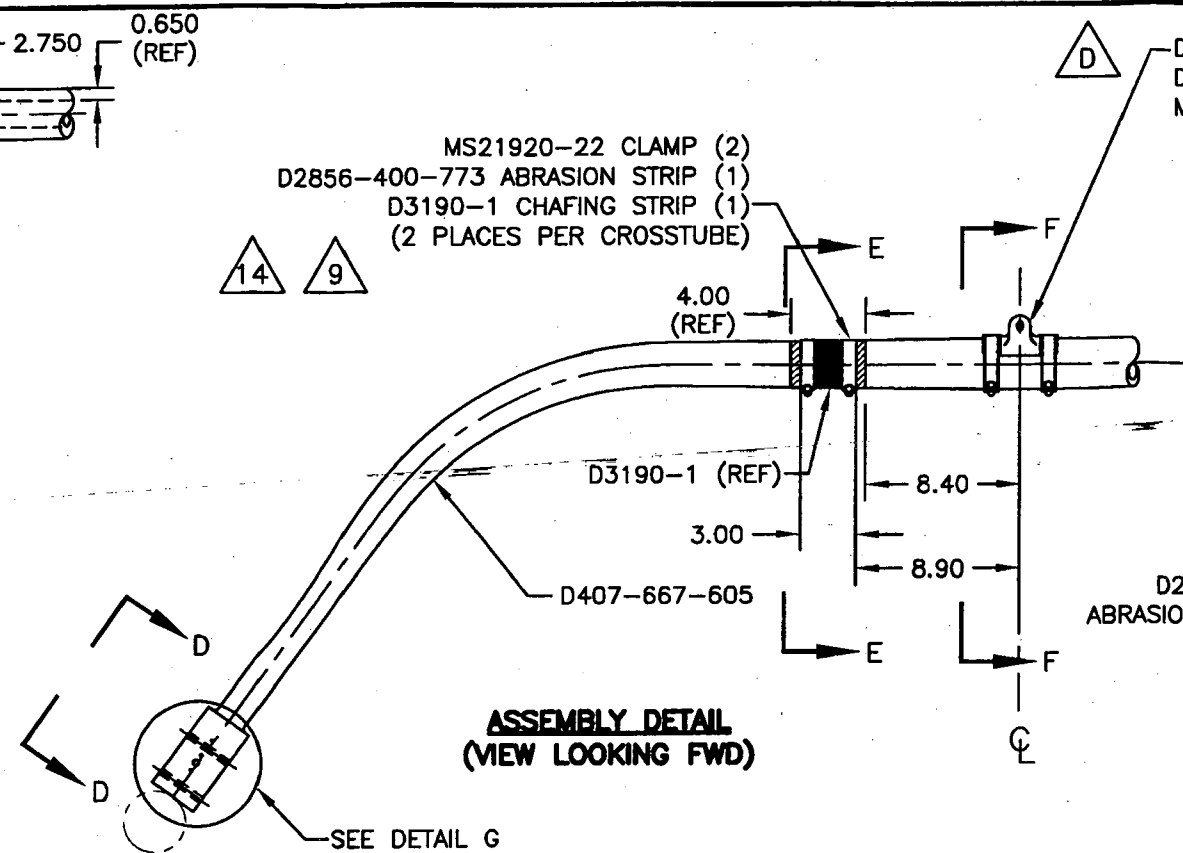
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39078

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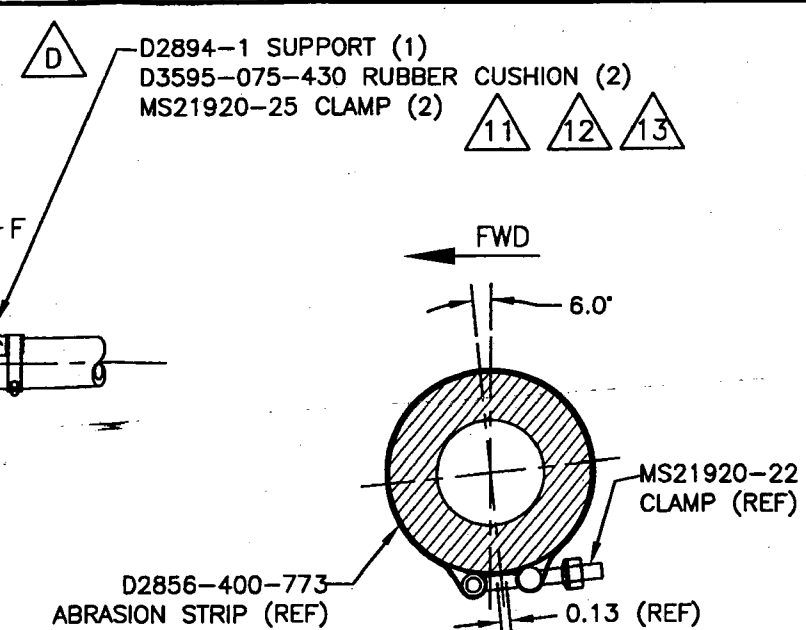
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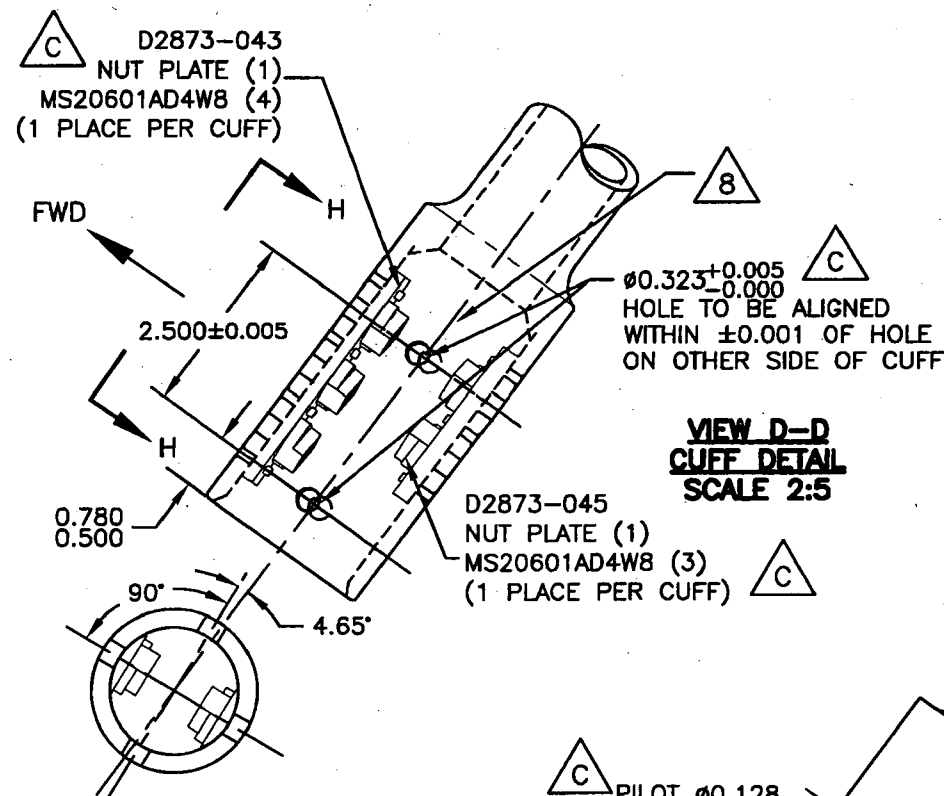
BENDING DETAIL 6



**ASSEMBLY DETAIL
(VIEW LOOKING FWD)**



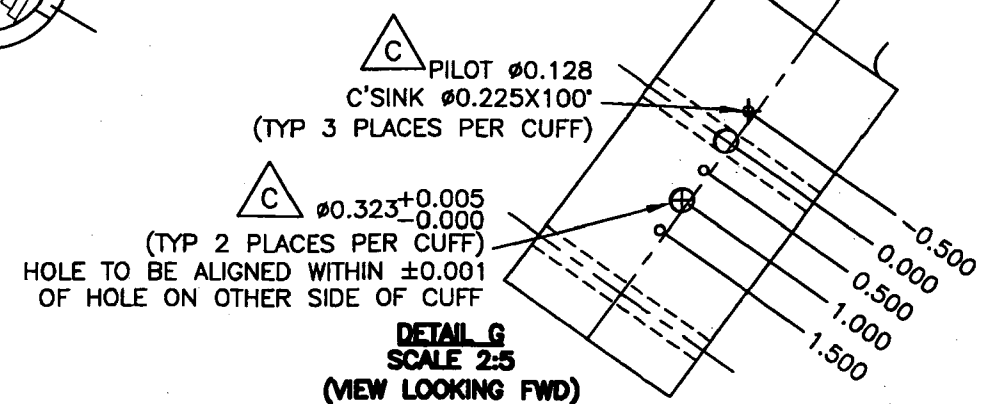
**SECTION E-E
SCALE 2:5**



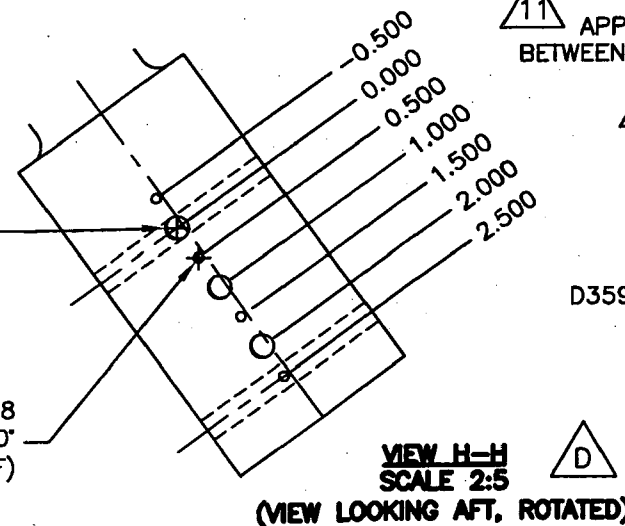
**VIEW D-D
CUFF DETAIL
SCALE 2:5**

Ø0.323±0.005
(TYP 3 PLACES PER CUFF)
HOLE TO BE ALIGNED WITHIN ±0.001
OF HOLE ON OTHER SIDE OF CUFF

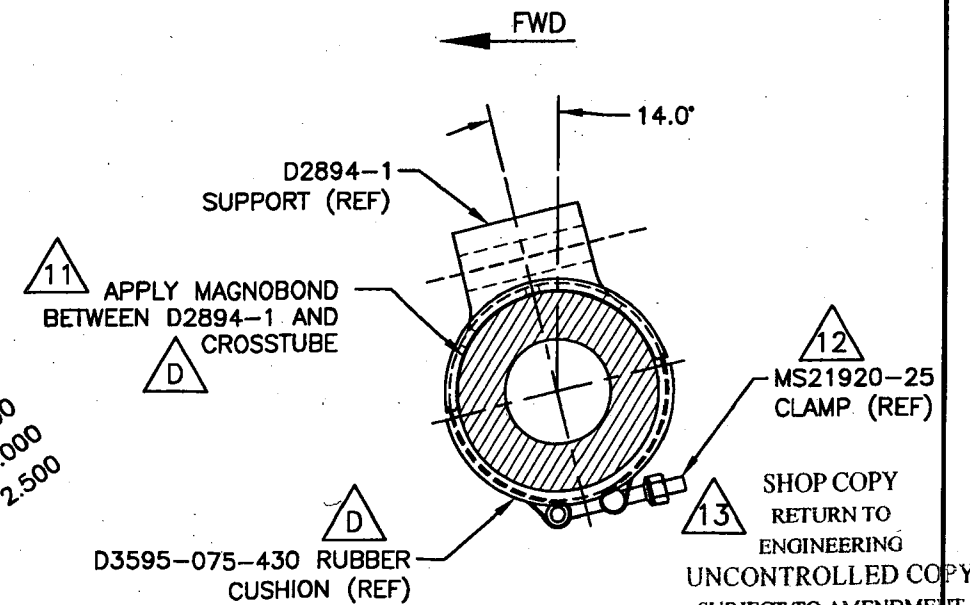
Ø0.128
C'SINK Ø0.225X100'
(TYP 4 PLACES PER CUFF)



**DETAIL G
SCALE 2:5
(VIEW LOOKING FWD)**



**VIEW H-H
SCALE 2:5
(VIEW LOOKING AFT, ROTATED)**



**SECTION F-F
SCALE 2:5**

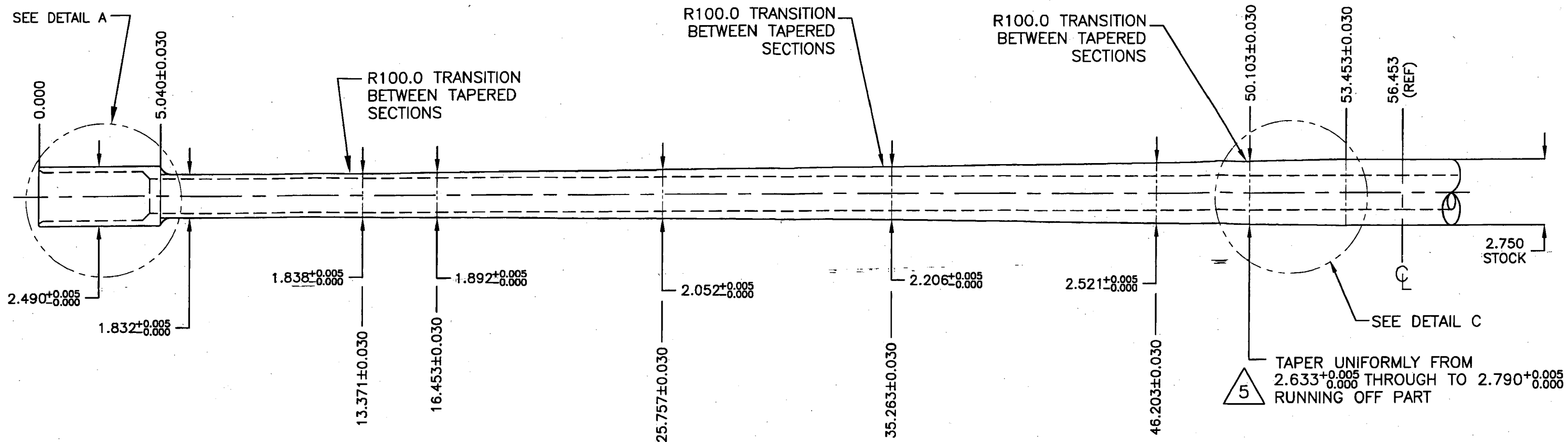
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RETURN TO
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WITHOUT NOTICE.
WORK ORDER
NO. 39078

07.02.14

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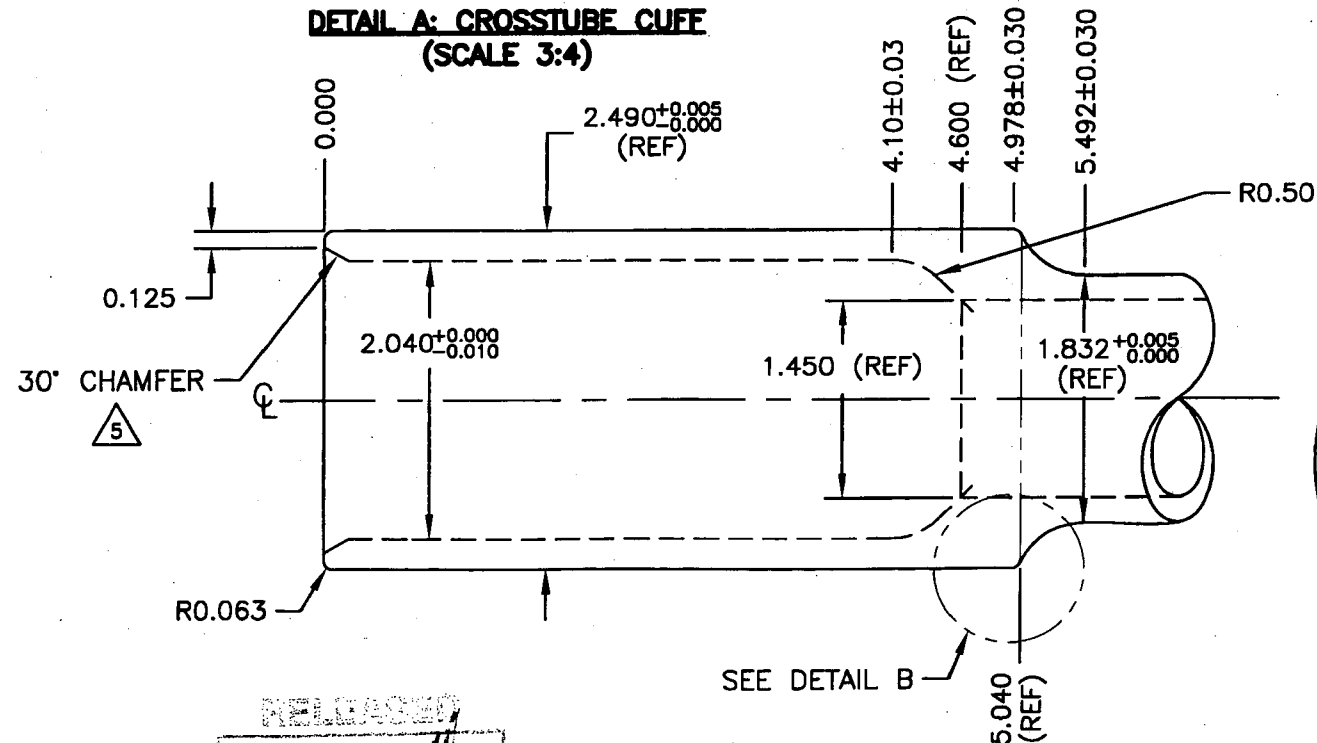
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DESIGN PH	DRAWN BY PH	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED PH	APPROVED PH	DRAWING NO. D407-667-245	REV. D SHEET 2 OF 3
DATE 07.02.07	TITLE CROSSTUBE ASS'Y (407 HIGH AFT)	SCALE 1:10	

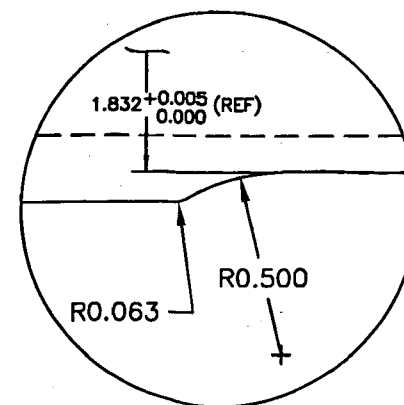


D407-667-245 MACHINING DETAIL

DETAIL A: CROSSTUBE CUFF
(SCALE 3:4)

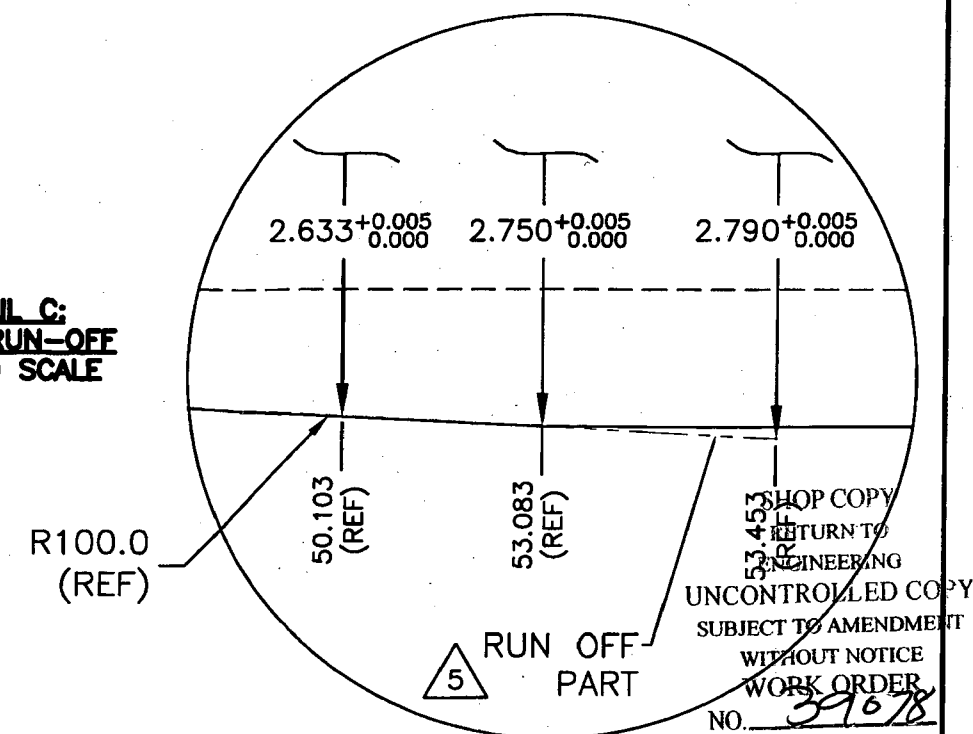


RELEASED
07.02.14



DETAIL B: CUFF
TRANSITION
SCALE 2:1

DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



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DESIGN PH	DRAWN BY PH	DART	DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED H	APPROVED H	DRAWING NO. D407-667-245	REV. D SHEET 3 OF 3
DATE 07.02.07		TITLE CROSSTUBE ASS'Y (407 HIGH AFT)	SCALE 1:4

